

FIG.1

- 2/6 -

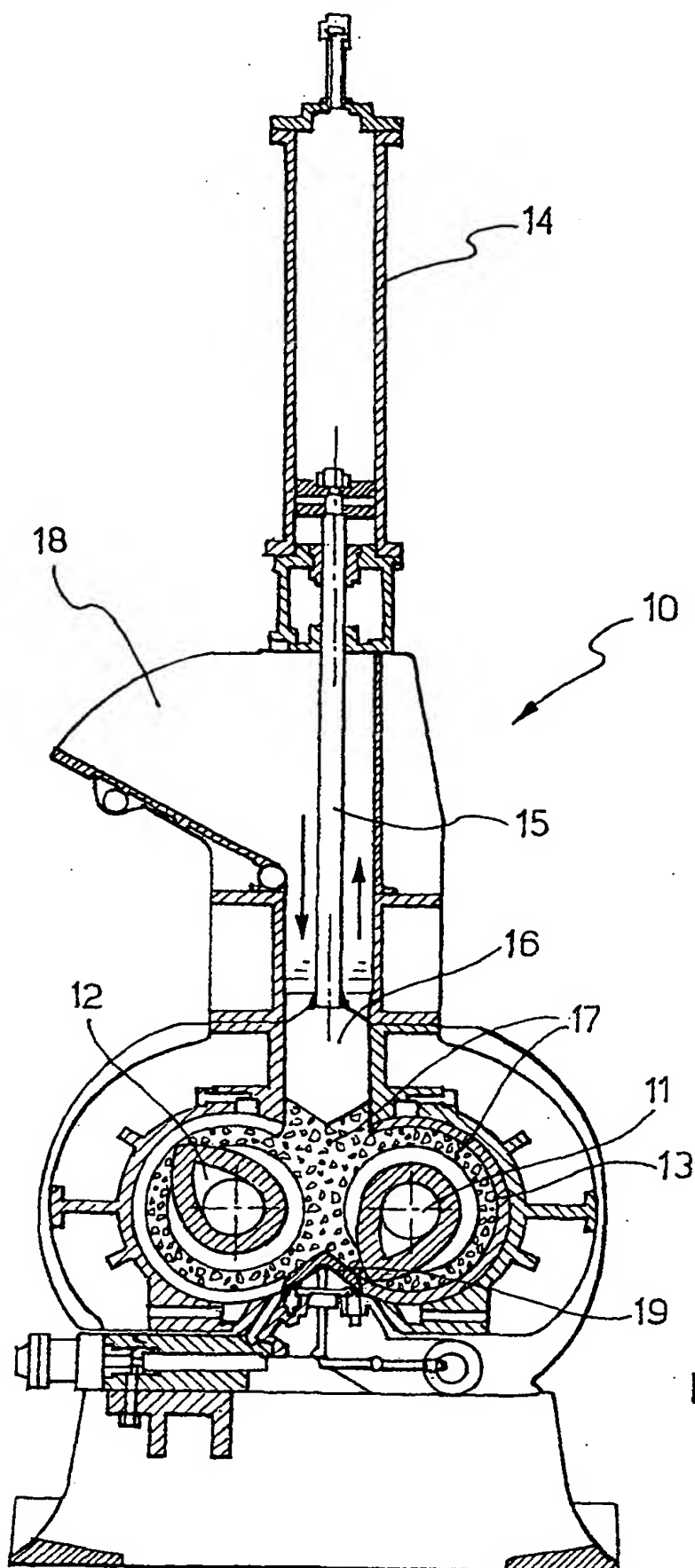


FIG. 2

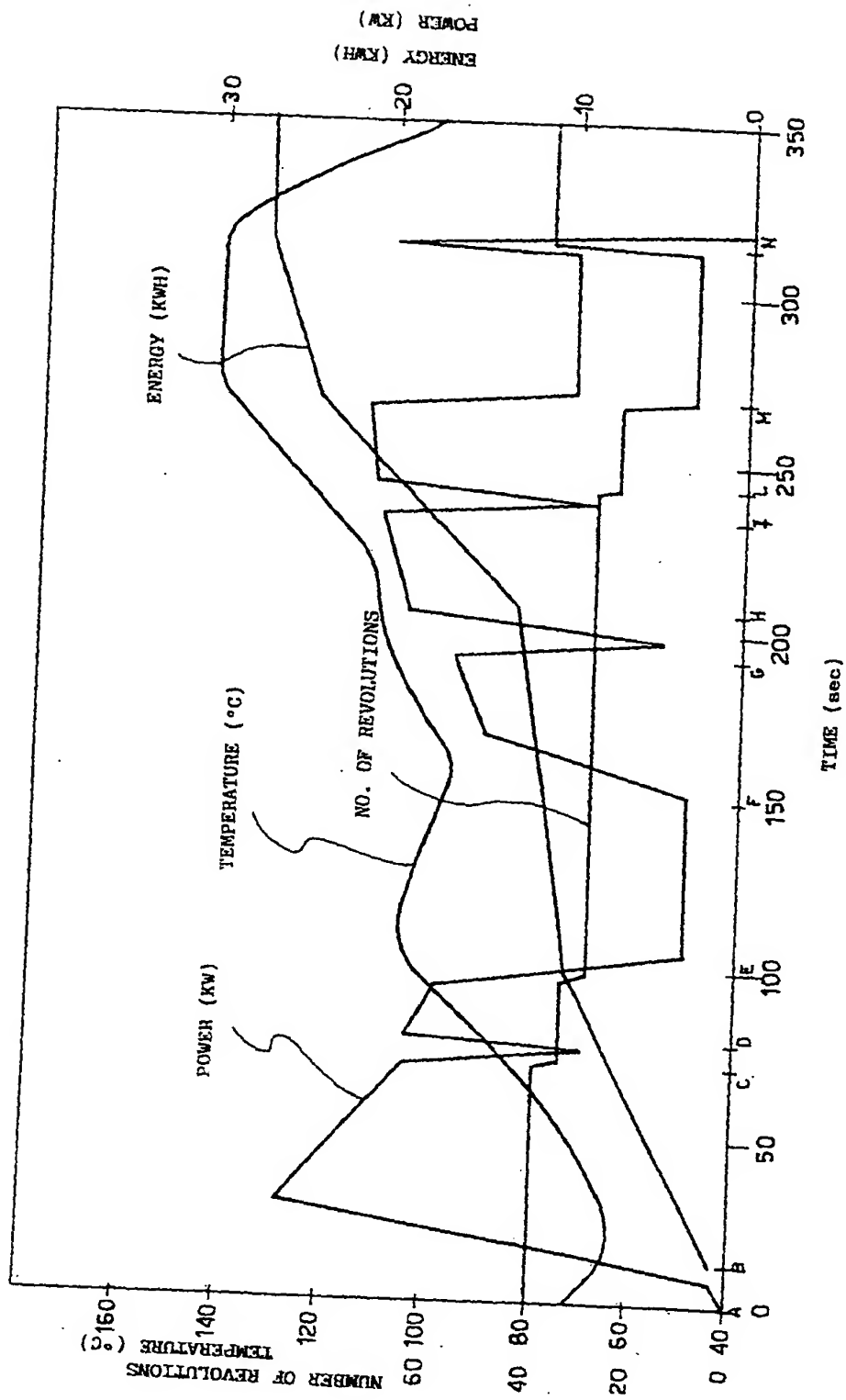


FIG. 3

- 4/6 -

PROCESS PARAMETERS	EXPECTED PROCESS PARAMETERS AND ASSOCIATED TOLERANCES				NON-COMPLIANCE WEIGHING				EXAMPLE OF CHECK FOR COMPLIANCE OF PROCESS PARAMETERS OF A BATCH WITH PREDEFINED LIMIT VALUES				BASIS: TOTAL SCORE
	MIXTURE				MIXTURE				MIXTURE				
	STEP NO.	Set value	Tol.-	Tol.+	WEIGHT	STEP NO.	ACTUAL VALUE WITHIN LIMITS?	SCORE		STEP NO.	ACTUAL VALUE WITHIN LIMITS?	SCORE	
STEP TIME (sec)	H-I	30	0	8	5	H-I	48 sec	NO	5				
PARTIAL TEMPERATURE (°C)	I	120	0	5	5	I	120 °C	YES	0				0-2 : NORMAL
PARTIAL ENERGY (KWH)	I	17.5	1.5	1.5	5	I	19.7 KWH	NO	5				21-30: DEFECTIVE 1st DEGREE
STEP TIME (sec)	L-M	25	5	5	7	L-M	42 sec	NO	7				
PARTIAL TEMPERATURE (°C)	M	145	0	0	0	M	145 °C	YES	0				
PARTIAL ENERGY (KWH)	M	24.5	2.4	2.4	8	M	27.7 KWH	NO	8				31-60: DEFECTIVE 2nd DEGREE
PARTIAL CYCLE TIME (sec)	N	315	45	125	10	N	470	NO	10				
TOTAL MIXING TIME (sec)	N	245	25	120	40	N	308	YES	0				
TOTAL ENERGY (KWH)	N	27.0	1.0	4.0	10	N	32.1	NO	10				> 60 : REJECT
PARTIAL TEMPERATURE (°C)	N	145	4	4	10	N	144	YES	0				
					100				45				DEFECTIVE 2nd DEGREE

Fig.4

- 5/6 -

REFERENCE CLASSIFICATION
$\leq 6$ min : NORMAL $> 6$ min / 9 min : DEFECTIVE 2 <sup>nd</sup> DEGREE $> 9$ min : REJECT

PROCESS PARAMETERS	DETECTED VALUE
MAINTENANCE TIME OF MIXTURE INSIDE THE EXTRUDER	11 min

▲ REJECT

FIG. 5

Fig. 6

